

Work Order ID 53778

November 18, 2009 12:37:31 PM



Page 1

Item ID: D2570

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bushing

Start Date: 18/11/2009 Start Qty: 400.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 400.00



Customer:

Reference:

Approvals:

Process Plan:

RD

Date: *09-11-18*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2570

Rev B

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Machine as per folio FA258 □ Debur

0.00

0.00

SD 09/12/10

415
272 *Ø*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SD 09/12/10

415
272 *Ø*

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

mmf
09/12/10

415 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53778

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Item ID: D2570

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bushing

Start Date: 18/11/2009 Start Qty: 400.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 400.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21 - Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

MF 09-12-18

09/12/21

MF
09-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53778

Parent Item: D2570RevB

Parent Item Name: Bushing

Comments:

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 400.00

Required Qty: 400.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	108.1000	32.4632			

303 Round Bar 0.750

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	108.1	
107077	0	
113134	108.1	

MF 09-18-18

1004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>53778</i>
Description: Bushing		Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

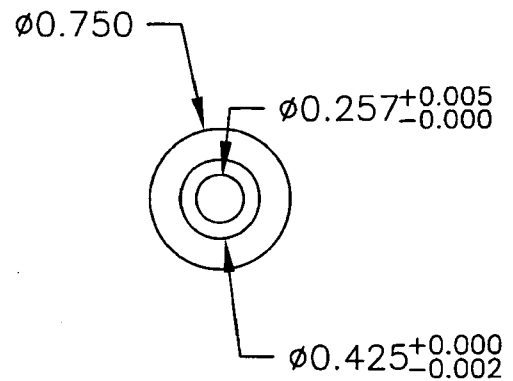
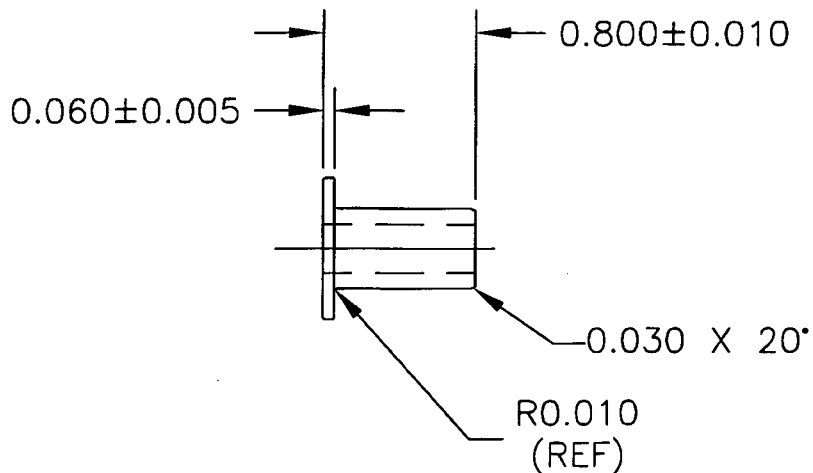
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	<i>.801</i>	/			
0.060	+/-0.005	<i>.062</i>	/			
R0.010	+0.010/-0.000	<i>R.015</i>	/			
Ø0.425	+0.000/-0.002	<i>Ø.427</i>	/			
Ø0.257	+0.006/-0.001	<i>Ø.259</i>	/			
Ø0.750	+/-0.010	<i>Ø.745</i>	/			
0.030 x 20°	+/-0.010	<i>Ø3x20°</i>	/			

Measured by: <i>[Signature]</i>	Audited by: <i>MNF</i>	Prototype Approval:	N/A
Date: <i>09/12/10</i>	Date: <i>09/12/10</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	<i>[Signature]</i>
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	<i>[Signature]</i>

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28**D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

UNCLAS

SUBJECT

WELL

WELL

NO. 53778

PH 09-11-18

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